

ABSTRACT OF THE DISCLOSURE

A set of calender rollers is described, which comprises at least three rollers, for rolling a plastic material into a plastic material sheet and for laminating the plastic material sheet onto a base material sheet at a nip portion to be formed into a laminated plastic material sheet, wherein

the nip portion is formed with a pair of nip rollers including a holding roller for holding the rolled plastic material sheet, and behind the nip portion, a release member for releasing the laminated plastic material sheet from the holding roller is arranged in proximity to or in contact with the holding roller.